January-09-13 8:50:08 AM Item ID: D4016-3 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Hinge Half, Lid Start Date: 1/09/13 **Start Oty: 18.00** \*18\* **Cust Item ID:** Required Date: 1/15/13 Req'd Oty: 18.00 \*18\* **Customer:** Reference: Run Approvals: **Process Plan:** MLJ Date: 13-01-09 Tooling: Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Reject Accept Insp. Work Center ID Description Run Hours Code Qty Otv Number Stamp Draw Nbr Revision Nbr D4016 Α 100 Cut blanks as per folio 0.00 \*100\* of 13/0/15 Bandsaw 0.00 Memo Jeaspa Bandsaw CUT BLANK as per folio 110 0.00 \*110\* HAAS I 0.00 Memo HAAS CNC vertical machine #1 MACHINE AS PER FOLIO FA874 AND DWG

**DEBURR** 

FOLIO REV: \_\_\_\_\_\_\_\_
DWG REV: \_\_\_\_\_\_\_

			DQA:	Date:	
ico v	•	MODE ODDED MON CONFORMANCE / LIDDATE	<del></del>		

NCR:	Yes	/ No				WORK ORDER NON-	CONFO	RIVIANCE / UI	PDATE	QA Closed:	Date	<u>:</u>
Work Ord	er.					DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
Part No.  NCR No.					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier			
Root		•			Descri	ption of work order update	Initial	Α	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief Er	ng Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							AULT CA	TECORY				•,
Landi	na G	Coor					AULI CA	IEGONT				
Lafigi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in ı Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes	Instru Maii Misla Misro Offse	ware ection Incomplete uctions Incomplete ntenance abeled ead	e/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		indralle M	IAVES IN F	- YTRUSIO	n I	HIRAWING	1 100011	n calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-09-13 8:50:08 AM

\*95317\*

Page 2

Item ID: D4016-3 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Hinge Half, Lid **Start Date:** 1/09/13 **Start Qty: 18.00** \*18\* **Cust Item ID:** Required Date: 1/15/13 Req'd Qty: 18.00 **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date: Stop QC: \_\_\_\_ Date: \_\_\_\_ SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty **Qty** Number Stamp 120 QC2- Inspect parts off machine FAI/FAIB 0.00 \*120\* 0.00 Memo Quality Control 130 QC8- Inspect parts - second check 0.00 \*130\* QC 0.00 Memo Quality Control Identify as per dwg & Stock Location: LAWY 0.00 160 \*160\* Packaging 0.00 Memo Packaging

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

		, 110						•			QA Closed:	Date	:
Work Ord	er:		Ξ"			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No.					Rework Scrap		Skid-tube Crosstube  Machining Small Fab		Small Fab	Water Je Prod. Eng. Coor		Engineering Quality	
NCR 1	NCR No.				Use-as-is Work Order Update	├  I		Finishing Composite	Rec/Store/Packaging Supplier		Other		
Root					Descri	ption of work order update	l:	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator								15					
Material													
Setup													
Other	_												
Process													
Supplier											:		
Training	<u> </u>										,		
Unapproved	L_		L	<u> </u>	L		<u> </u>				<u> </u>	1	
							AUL	T CATE	GORY			. <del></del>	
Landi		3				General		C			Ovalized	Г	Pressure/Forced
	$\vdash$	Bending	-+ C		0/5	Bend BOM/Route	-	Grain Hardwa			Ovalized Over/Under	talaransa	Temperature/Cure
	$\vdash$	Centre No Cracks	ot Concei	ntric to	<sup>0/5</sup>  -	Broken/Damaged	$\vdash$		ire ion Incomplete		Part Incorre	<b>⊢</b>	Weld
	⊢	Crushed/	Crimpad			Burrs	$\vdash$		ion incomplete/	Unclear	Part Lost/M	<b>⊢</b>	Wrong Stock Pulled
	$\vdash$	Cuffs	cimped.	-	-	Contamination	$\vdash$	Mainte	•	Unicieal	Part Moved		
	-	Heat Trea	ıt.		-	Countersink	$\vdash$	Mislabe			Positioned \		
	⊢	Inspection		Tube	<del>                                     </del>	Cut Too Short	$\vdash$	Misrea		<u> </u>	Power Loss/	_	Other
	-	Ripples in				Drill Holes	-	Offset	-	L	7. 3 2333/		1
	一	Torque W		xtrusio	n	Drawing	-		Calibration				
	Г	Turning S				Finish	$\vdash$		Sequence				• • • • • • • • • • • • • • • • • • • •

Outside Dimensions

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5

Wave/Twist in Tube

Folio

January-09-13 8:50:08 AM

\*95317\*

Page 3

Item ID: D4016-3 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Hinge Half. Lid **Start Date:** 1/09/13 **Start Qty: 18.00** \*18\* Cust Item ID: Required Date: 1/15/13 Req'd Qty: 18.00 \*18\* **Customer:** Reference: Run Process Plan: Approvals: Tooling: Date: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Reject Tool # Plan Accept Insp. **Work Center ID Description Run Hours** Code Qty Qty Number Stamp 170 QC21- Final Inspection - Work Order Release 0.00 \*170\* 0.00 Memo Quality Control

DQA:	Date:		

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	e:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	0				Rework Scrap Use-as-is Work Order Update	- I	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
	<u> </u>		1	5 .		1 1.747.1	Λ.	A:	C: 0		
Root					ption of work order update	Initial		tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	_										
quip/Tooling											
Operator											
Material											
Setup											
Other											
Process		İ									
Supplier											
Training	_										
Unapproved		1								<u> </u>	
						AULT CATE	GORY				
Landin F	ig Gear			_	General	<b>п</b> .		<u></u>	7	г	¬
}	Bending	_			Bend	Grain		ļ	Ovalized	<b>}</b>	Pressure/Forced
1	Centre No	ot Conce	ntric to (	o/s	BOM/Route	Hardw		<u> </u>	Over/Under	- F	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	$\vdash$	tion Incomplete	, <u> </u>	Part Incorre	F	Weld
	Crushed/	Crimped		<u> </u>	Burrs	<b></b>	tions Incomplete/	'Unclear	Part Lost/M	issing [	Wrong Stock Pulled
<u> </u>	Cuffs			_	Contamination	<b>—</b>	enance	<u> </u>	Part Moved		
ļ	Heat Trea				Countersink	Mislab		_	Positioned \		
	Inspectio		Tube	<u> </u>	Cut Too Short	Misrea		L.	Power Loss/	Surge	Other
	Ripples in			L	Drill Holes	Offset					
Ļ	Torque W			n	Drawing	$\vdash$	Calibration				
1	Turning S				Finish	<del> </del>	Sequence		•		
	Wave/Tw	ist in Tul	эe		Folio	Outsid	e Dimensions				

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## **Picklist Print**

January-09-13 8:50:13 AM

Work Order ID: 95317

\*95317\*

Parent Item:

D4016-3

\*D4016-3\*

Parent Item Name: Hinge Half, Lid

**Start Date: 1/09/13** 

Required Date: 1/15/13

**Start Qty: 18.00** 

Required Qty: 18.00

Comments:

I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD

IPP Rev:B as

per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	*
M304B1.000X1.000		Purchased	No			100	f	10.9800	0.08	1.515789				
*M304B1	000X1 (	<b>)</b>							**	1.51570)				

304 bar 1.00 x 1.00

<b>Location</b>	Loc Qty	Loc Code
MAT049	10.98	
122008	10.98	

1.52 al 13/01/15

				DQA:	Date:	
 		MACOUL CODED MAN CONTRODA AND CO	r / UDD ATC			

NCR: Yes / No **WORK ORDER NON-CONFORMANCE / UPDATE** QA Closed: Date: DISPOSITION **AGAINST DEPARTMENT/PROCESS** Work Order: Crosstube Water let Engineering Rework Skid-tube Small Fab Prod. Eng. Coor. Quality Part No. Scrap Machining Thermoforming Finishing Rec/Store/Packaging Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Initial Action Sign & Root Chief Eng QC Inspector Date Step Qty or Non-conformance Description Date Verification Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Bending Grain Ovalized BOM/Route Temperature/Cure Over/Under tolerance Centre Not Concentric to O/S Hardware Broken/Damaged Weld Cracks Inspection Incomplete Part Incorrect Crushed/Crimped. Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Other Cut Too Short Misread Power Loss/Surge Inspection Strip in Tube **Drill Holes** Offset Ripples in Bend Out of Calibration Torque Waves in Extrusion Drawing

Out of Sequence

**Outside Dimensions** 

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95317
Description: Hinge Half, Lid	Part Number:	D4016-3
Inspection Dwg: D4016 Rev: A		Page 1 of 1

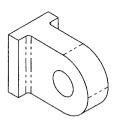
## FIRST ARTICLE INSPECTION CHECKLIST

0.88 0.13 0.250 R0.03 0.13 0.50 0.63 0.563 Ø0.257	+/-0.030 +/-0.030 +/-0.010 +/-0.030 +/-0.030 +/-0.030	-880 -126 -249 -030 -126 -500		Jan Sp B	
0.250 R0.03 0.13 0.50 0.63 0.563	+/-0.010 +/-0.030 +/-0.030 +/-0.030 +/-0.030				
R0.03 0.13 0.50 0.63 0.563	+/-0.030 +/-0.030 +/-0.030 +/-0.030				
0.13 0.50 0.63 0.563	+/-0.030 +/-0.030 +/-0.030			·	
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0.63 0.563	+/-0.030	-500			
0.563					
		625			
Ø0.257 -	+/-0.010	.563			
	+0.006/-0.001	-257			

Measured by:	Audited by:	and	Preliminary Approval:	
Date: 13-01-16	Date:	13/0/11	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	(KJ 9X)	
				• • •

**D4016-1 HINGE HALF, BASE** 



D4016-3 HINGE HALF, LID

SHOPCOLL

RETURN +

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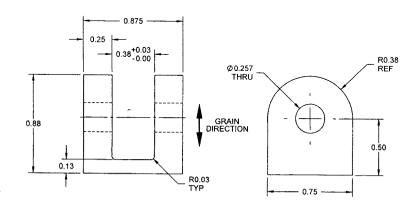
WORK 137 MLJ 1301-09

**D4016-5 HINGE HALF, LIGHT LID** 

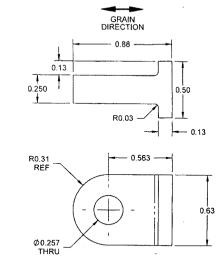
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Α	NEWIS	NEW ISSUE			10.01.29
REV.		DESCRIPTION			DATE
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		AJS			
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		77	D4016		SHEET 1 OF 2
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID D4016-5 HINGE HALF, LIGHT LID

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NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B

Đ

REF DART SPEC MODDITOB

2) FINISH: NONE
3) TOPERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs
-3: 0.04 lbs
-5: 0.01 lbs

5